

Date: Tuesday, 07/04/2009 10:18:55 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 46960	
Estimate Number : 10330	
P.O. Number :	Part Number : D2746
This Issue : 07/04/2009 S.O. No. :	Drawing Number : D2746 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 43599	Material :
Written By :	Due Date : 30/04/2009 Qty: 10 Um: Each
Checked & Approved By : JUD 09-04-07	
Comment :	
Est Rev: D 02.10.24 Re-format KJ	
Est Rev: E 06-03-21 as Per Rev C JLM	
Est Rev: F 06-06-12 Now On Waterjet JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025 SHEET
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Comment: Qty.: 0.4263 sf(s)/Unit Total : 4.2630 sf(s)
 1010/1025/A21/6aA .040" SHEET
 (M1010S20GA)
 Batch: 110368 IR 9-4-22

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2746
 Dwg Rev: C
 Prog Rev: C

IR 9-4-22

(14)

2-Deburr if necessary IR 9-4-22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 09/04/22 (H4)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary.

u / A S

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:18:55 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 46960

Part Number: D2746

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form on CNC Brake as per Dwg D2746 using Jigs DT8261 and DT8326
2-Form joggle on Punch as per Dwg D2746 using Jig DT8158 Identify as D2746

SB 09/04/24 (14)
09/04/24 (14)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/04/24 (14)

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 109091

START TIME:

9:00

OVEN TEMPERATURE:

320°

FINISH TIME:

9:30

(14)

BL 09-04-27

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

41

09-04-27 (14)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 496A

PC 9/4/27 (14)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/28

Job Completion



MF 09-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

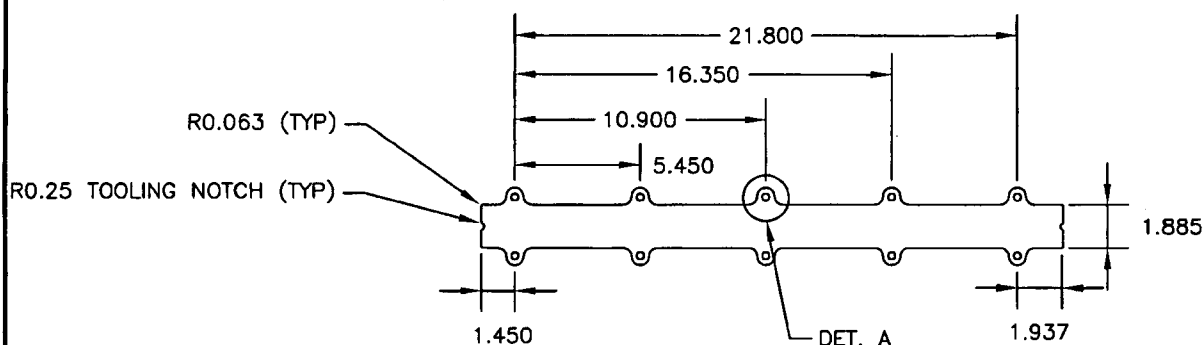
NOTE: Date & initial all entries

DART

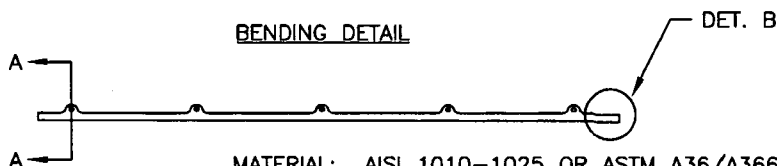
RELEASED
06-20-07

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
PJ1	PJ1	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. C	
		D2746	SHEET 1 OF 1	
DATE		TITLE	SCALE	
06.01.12		WEARSHOE	1:8	
A	98.04.16	NEW ISSUE		
B	98.08.18	RE-DESIGN		
C	06.01.12	ENLARGE HOLES TO IMPROVE FIT		

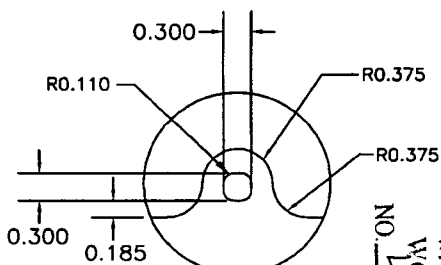
FLAT PATTERN



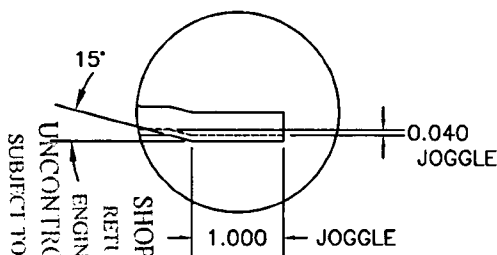
BENDING DETAIL



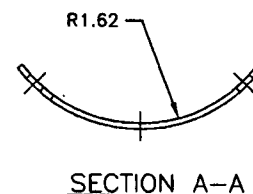
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)



DETAIL A



DETAIL B



SECTION A-A

NOTES

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL, 20 GAUGE (0.040 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) THIS PART CAN BE MADE BY MODIFYING D2656-21

NO. 10100
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT

UNCONTROLLED COPY
RETURN TO
ENGINEERING
SHOP COPY